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Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [03/2023 -]
Title: EXTERIOR PANELS / TRIM: REAR DOOR WINDOW FRAME MOULDING: REMOVAL; 2023 - 2024 MY Prius Prius Prime [03/2023 -]		

REMOVAL

CAUTION / NOTICE / HINT

The necessary procedures (adjustment, calibration, initialization or registration) that must be performed after parts are removed and installed, or replaced during rear door window frame moulding removal/installation are shown below.

Necessary Procedures After Parts Removed/Installed/Replaced

REPLACED PART OR PERFORMED PROCEDURE	NECESSARY PROCEDURES	EFFECT/INOPERATIVE FUNCTION WHEN NECESSARY PROCEDURES ARE NOT PERFORMED	LINK
<ul style="list-style-type: none"> • Power window regulator motor assembly LH • Power window regulator motor assembly RH • Rear door window regulator sub-assembly LH* • Rear door window regulator sub-assembly RH* • Rear door glass sub-assembly LH* • Rear door glass sub-assembly RH* • Rear door glass run LH* • Rear door glass run RH* 	Initialize power window control system	<ul style="list-style-type: none"> • Auto up and down function • Remote control function • Key-off operation function • Wireless transmitter-linked function • Key-linked function • Window open warning function • Catch protection function • Jam protection function 	INFO
*: Even when not replacing the part, it is necessary to perform the specified necessary procedures after installation.			

CAUTION / NOTICE / HINT

NOTICE:

- After the ignition switch is turned off, the radio and display receiver assembly records various types of memory and settings. As a result, after turning the ignition switch off, make sure to wait at least 3 minutes before disconnecting the cable from the negative (-) auxiliary battery terminal.

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- When the cable is disconnected from the negative (-) auxiliary battery terminal and the security lock setting has been enabled, multi-display operations will be disabled upon next startup unless the password is entered. Be sure to check the security lock setting before disconnecting the cable from the negative (-) auxiliary battery terminal.

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CAUTION / NOTICE / HINT

HINT:

- When the cable is disconnected / reconnected to the auxiliary battery terminal, systems temporarily stop operating. However, each system has a function that completes learning the first time the system is used.

Learning completes when vehicle is driven

EFFECT/INOPERATIVE FUNCTION WHEN NECESSARY PROCEDURES ARE NOT PERFORMED	NECESSARY PROCEDURES	LINK
Front Camera System	Drive the vehicle straight ahead at 35 km/h (22 mph) or more for 5 seconds or more.	INFO

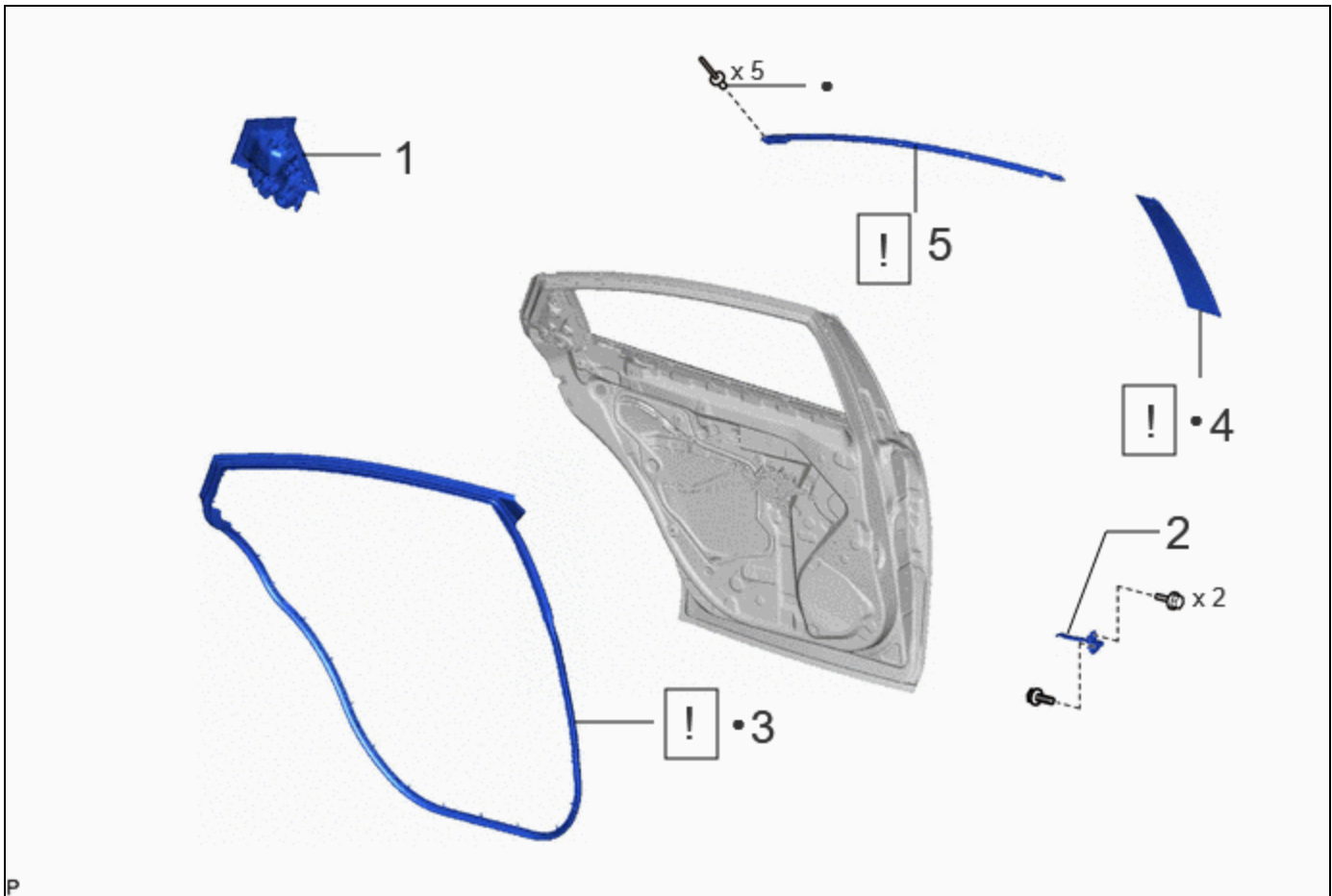
Learning completes when vehicle is operated normally

EFFECT/INOPERATIVE FUNCTION WHEN NECESSARY PROCEDURES ARE NOT PERFORMED	NECESSARY PROCEDURES	LINK
Power Door Lock Control System*1 <ul style="list-style-type: none"> Back door opener 	Perform door unlock operation with door control switch or electrical key transmitter sub-assembly switch.	INFO
Power Back Door System*2	Reset back door close position	INFO
Air Conditioning System	for HEV Model: After the ignition switch is turned to ON, the servo motor standard position is recognized. for PHEV Model: After the ignition switch is turned to ON, the servo motor and expansion valve standard position is recognized.	-
*1: w/o Power Back Door System *2: w/ Power Back Door System		

- Use the same procedure for the RH side and LH side.
- The following procedure is for the LH side.

CAUTION / NOTICE / HINT

COMPONENTS (REMOVAL)



PROCEDURE		PART NAME CODE			
1	REAR DOOR OUTSIDE HANDLE ASSEMBLY	69240	-	-	-
2	REAR DOOR CHECK ASSEMBLY	68630	-	-	-
3	REAR DOOR WEATHERSTRIP	67872	INFO	-	-
4	REAR DOOR WINDOW FRAME FRONT MOULDING	75762A	INFO	-	-
5	REAR DOOR WINDOW FRAME UPPER MOULDING	75764A	INFO	-	-

•	Non-reusable part	-	-
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PROCEDURE


1. REMOVE REAR DOOR OUTSIDE HANDLE ASSEMBLY

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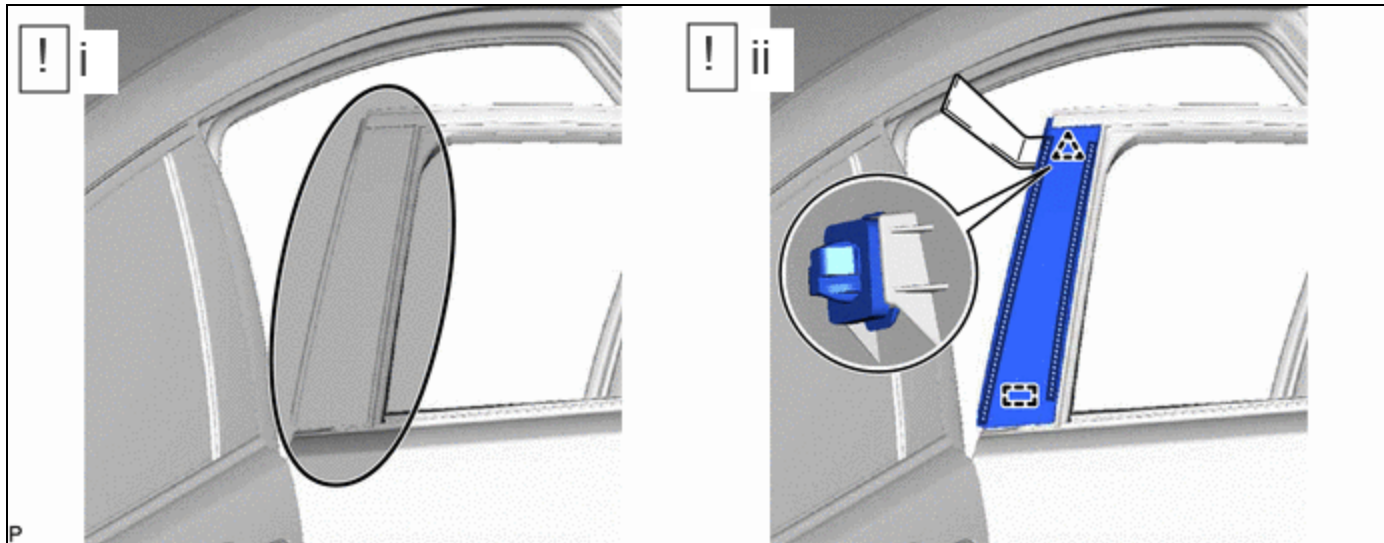
2. REMOVE REAR DOOR CHECK ASSEMBLY


Click here [INFO](#)

3. REMOVE REAR DOOR WEATHERSTRIP

	Click here INFO
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4. REMOVE REAR DOOR WINDOW FRAME FRONT MOULDING



	Heating Area	-	-
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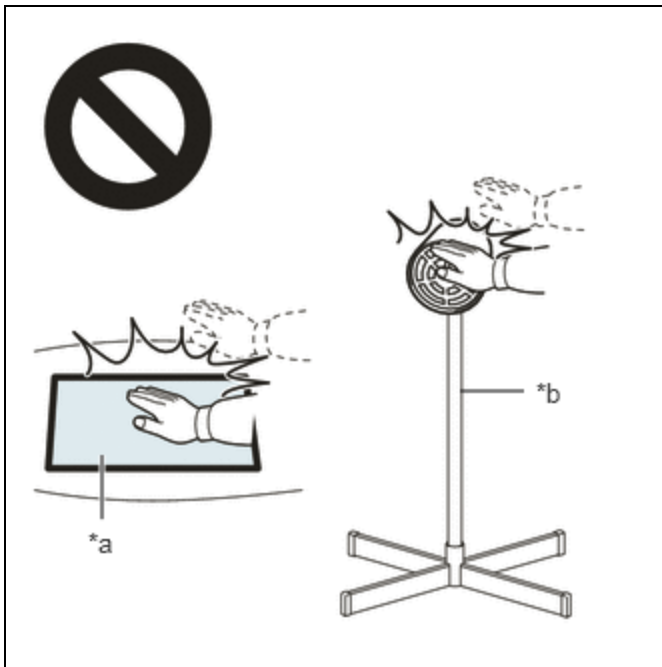
(1) Using a heat light, heat the vehicle body and rear door window frame front moulding surface.

Heating Temperature

AREA	TEMPERATURE	AREA	TEMPERATURE
Rear Door Window Frame Front Moulding and Vehicle Body	40 to 60 °C (104 to 140 °F)	-	-

CAUTION:

- Do not touch the heat light and heated parts, touching the heat light may result in burns.
- Touching heated parts for a long time may result in burns.



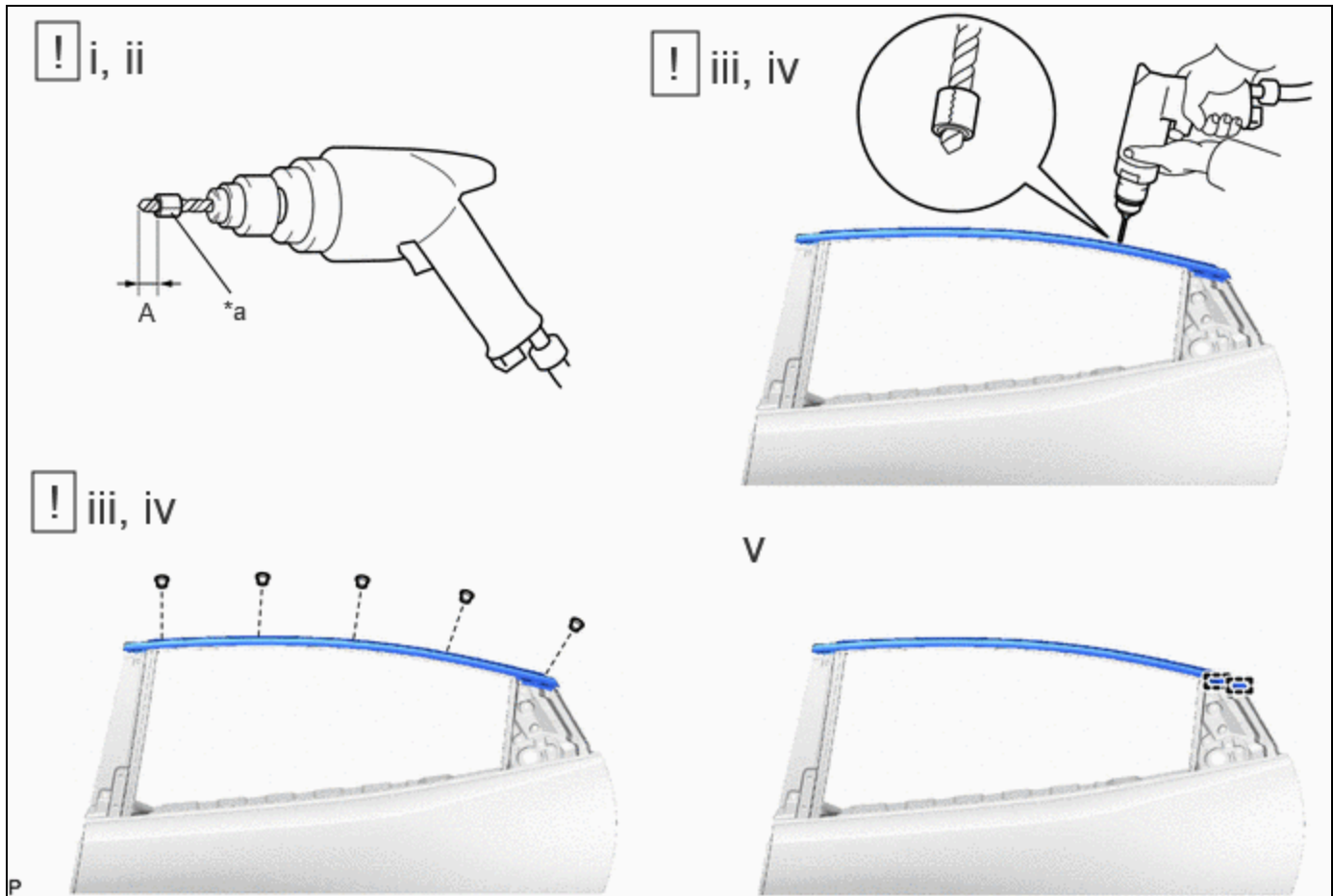
*a	Heated Part
*b	Heat Light

NOTICE:

Do not heat the vehicle body and rear door window frame front moulding excessively.

- (2) Using a moulding remover, disengage the clip, guide and separate the double-sided tape to remove the rear door window frame front moulding.

5. REMOVE REAR DOOR WINDOW FRAME UPPER MOULDING



*a	Tape	-	-
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- (1) Insert a 4.0 mm (0.157 in.) drill bit into a drill.
 - (2) Tape the 4.0 mm (0.157 in.) drill bit 5.0 mm (0.197 in.) from the tip as shown in the illustration.
- Standard Measurement:

AREA	MEASUREMENT	AREA	MEASUREMENT
A	5.0 mm (0.197 in.)	-	-

NOTICE:

Tape the 4.0 mm (0.157 in.) drill bit to prevent the drill bit from going too deep.

- (3) Lightly press the drill against the rivets to drill off the rivet flanges, and remove the 5 rivets.

CAUTION:

Be careful of the drilled rivets, as they may be hot.

NOTICE:

- Pressing the drill too firmly will cause the rivet to turn and result in the rivet not being drilled through.
- Prying the rivets with the drill may damage the rivet installation holes or drill bit.

- (4) Using a vacuum cleaner, remove the rivet fragments and shavings from the drilled areas.
- (5) Disengage the 2 guides and remove the rear door window frame upper moulding.

